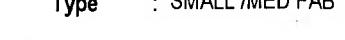


Date: Wednesday, 5/23/2007 3:24:11 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STRUT		
Job Number	: 32461			Part Number	: D2565101		
Estimate Number	: 10273			Drawing Number	: D2565 REV E		
P.O. Number	: N/A			Project Number	: N/A		
This Issue	: 5/23/2007	S.O. No.	: N/A	Drawing Revision	: E		
Prsht Rev.	: NC			Material	: N/A		
First Issue	: N/A			Due Date	: 5/29/2007		
Previous Run	: 27647			Qty:	10	Um:	Each
Written By							
Checked & Approved By	:  07/05/2014						
Comment	Est:	F	04.16	Added dwg Rev.C1 NG			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W 
		Comment: Qty.: 1.7955 f(s)/Unit Total : 17.9550 f(s) 304 RD TUBE .750 X.49W Material :304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall per Dwg (M304TR0750W049) Batch <u>M 103 240</u> FF 07-05-28
2.0	BRAKE NC	NC BRAKE 
		Comment: NC BRAKE Punch as per Dwg D2565 using DT 8313
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr and polish KM 07/05/30
4.0	QC5	INSPECT WORK TO CURRENT STEP 
		Comment: INSPECT WORK TO CURRENT STEP SB 07/05/30
5.0	POWDER COATING	POWDER COATING 
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 M 103 141 BL 07-05-31 P10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/05 S		Markings on tube showing through paint	07/06/05 OSRA12	baff out + repaint per QSI 005	07/06/05 07/04/05 OSRA12	07/06/05 07/04/05 OSRA12	07/06/05 07/04/05 OSRA12	07/06/05 07/04/05 OSRA12

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:24:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 32461

Part Number: D2565101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



10X

M-t

07/06/04

Comment: INSPECT POWDER COAT

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 259

W 7/6/04 50

10X

8.0 QC21

FINAL INSPECTION/W/O RELEASE



10X

7/6/04 50

P 07/06/05

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 07/06/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

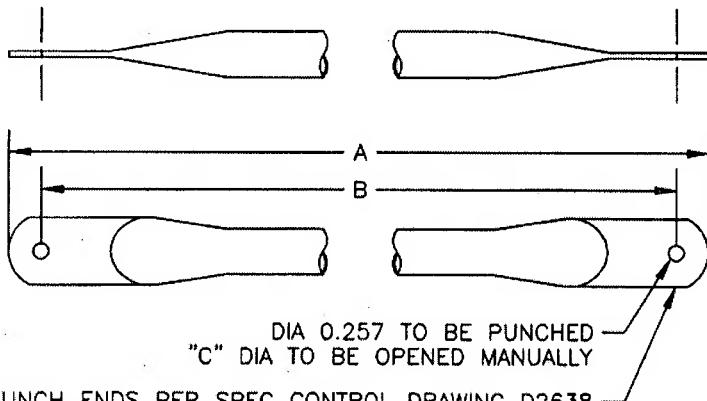
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2565 REV. E SHEET 1 OF 1
DATE 04.05.05	TITLE STRUT	SCALE 1:3

RELEASED
 04.05.05

A	96.05.03	NEW ISSUE
B	97.03.15	CORRECT D2565-111 DIM. A
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)
D	02.06.05	ADD -3XX PARTS; ADD FINISH
E	04.05.05	ADD D2565-401-411; RMV ANGLE D



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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